



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3147-1
Job Sheet 211988



Part No: D3147-1

Job Qty: 10 pcs

Part Name: Pin



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/4/20

Job Tracking No:

Due Date: 8/12/20

Created By: Marie Lajeunesse

Type: Stock **SOLD**

Description:

Note: DWG REV C IPP Rev A New Issue 07-01-26 JLM IPP Rev:B Now on Cnc 07-05-02 JLM IPP Rev:C Now on Doosan 08-10-14 JLM Verified By:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	10 pcs	8/12/20	8/12/20	1.00	3.45	Doosan - 1		20-08-06
110	QC 2	10 pcs	8/12/20	8/12/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		20-08-06
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



Container No: S292445



Part: D3147-1

Job No: 211988

Serial No/Batch: S292445

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
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www.dartaerospace.com

Date: 08/06/20

				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
120	QC 8	10 pcs	8/12/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
					QC 8 - 66
					QC 8 - 73
					QC 8 - 82
130	Packaging 3-1 - Stock - B4B	10 pcs	8/12/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B

DAS

33

20/07/08

9-89

DAS

28

9-89

AUG 07 2020

140 QC 21 - SA	10 pcs	8/12/20	0.00 0.00	Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 37 - B4B	
				QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 9	9-95
				QC 21 - SA - 77	

AUG 07 2020

Part Op 100 - (Doosan Lathe) 1-TURN AS PER FOLIO FA691 & DWG D3147 ,
 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
 120 - (QC8- Inspect parts - second check)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R0.187	M303R0.187	2.2500 ft (.225 ea)	100-Doosan - 1	1127864

10x2.75

+2.75

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M303R0.187	2	8	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Pin	2.500inches ± 0.010	2.510 2.490	2.498	
2	Pin	0.200inches ± 0.010	0.210 0.190	2	
3	Pin	5.000Degrees ± 0.500	5.500 4.500	5	
4	Pin	0.080inches ± 0.030	0.110 0.050	.08	Radius
5	Pin	0.010inches ± 0.010	0.020 0.000	.01	Radius
6	Pin	0.125inches + 0.004 - 0.001	0.129 0.124	.1255	Diameter
7	Pin	0.150inches ± 0.010	0.160 0.140	.149	
8	Pin	0.090inches ± 0.030	0.120 0.060	.09	Radius
9	Pin	0.200inches ± 0.010	0.210 0.190	.2	
10	Pin	0.181inches ± 0.010	0.191 0.171	.187	Diameter
11	Pin	0.620inches ± 0.010	0.630 0.610	.618	
12	Pin	0.111inches ± 0.010	0.121 0.101	.112	
13	Pin	0.010inches ± 0.030	0.040 (0.020)	.01	Radius

Plex 8/4/20 7:21 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					